

Date: Monday, 1/7/2008 11:33:38 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BAFFLE ASSEMBLY		
Job Number	: 36597					
Estimate Number	: 11265					
P.O. Number	:			Part Number	: D3276042	
This Issue	: 1/7/2008		S.O. No. :	Drawing Number	: D3276 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 36503			Material	:	
Written By	:			Due Date	: 1/30/2008	
Checked & Approved By	:			Qty:	12 Um: Each	
Comment	: Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S040	6061-T6 .040 Sheet	
		Comment: Qty.: 1.0715 sf(s)/Unit Total : 12.8583 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.040" thick (M6061T6S.040) Batch: 106747 HB 8-1-9	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3276 Dwg Rev: B HB 8-1-9 Prog Rev: B (12)	
		2-Deburr if necessary HB 8-1-9	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	HB 8-1-9 (12)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Deburr	
		2-Roll as per Dwg D3276	HB 08/01/15 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 08/01/15 (12)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/01/15 (12)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-01-16

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/01/17 (12)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-01-07

11.0 D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 27.0000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

35433

AS 08/01/18 (12)

12.0 D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

36663

AS 08/01/18 (12)

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

SB 08/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC5 INSPECT WORK TO CURRENT STEP



AS C 08/01/22 X12

Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 179

AS 08/01/22 X12

16.0 QC21 FINAL INSPECTION/W/O RELEASE



08.01.23 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Jan 2008/1/23

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

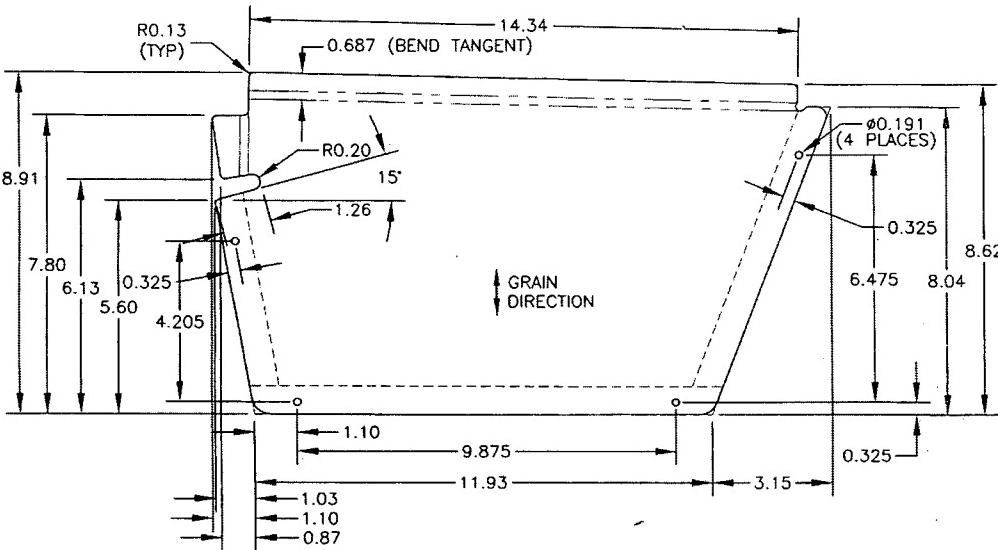
DART AEROSPACE LTD	Work Order:	36597
Description: Baffle	Part Number:	D3276-1
Inspection Dwg: D3276	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

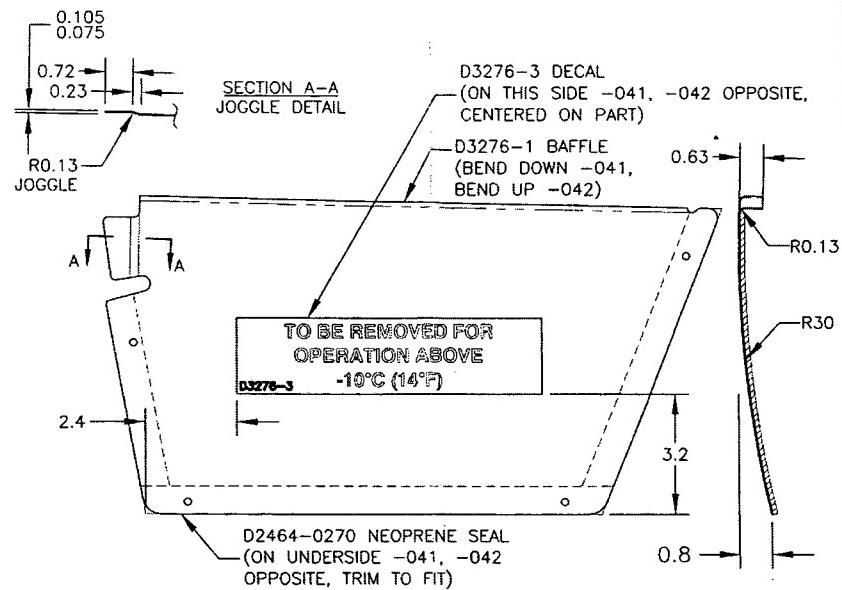
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	8/11/09	Date:	8/11/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D044-717-011	KJ/JLM	SJL

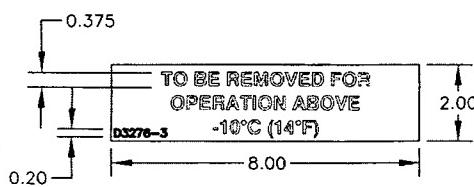


D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32591

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DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3276	REV. B SHEET 1 OF 1
DATE 05.01.25	TITLE BAFFLE ASSEMBLY	SCALE 1:3	

RELEASED
05-02-02